QC

Quality Control

Memo

NCR: Ye	es / No				WORK ORDER NON-O	CON	IFORN	MANCE / UP	DATE		•	
										QA Closed:	Date:	
Work Orde	r:				DISPOSITION				AGAINST DE	PARTMENT,		
					Rework	╛┪		Skid-tube	Crosstube		Water Jet	Engineering
Part N	0				Scrap			Machining	Small Fab	l	d. Eng. Coor.	Quality
NCR N	0				Use-as-is Work Order Update	}		noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root				Descri	ption of work order update	lt	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
quip/Tooling												
Operator		Ì										
Material		l										
Setup						1						
Other												
Process		l				1						
Supplier												
Training [
Jnapproved		1										
					F	AUL	T CATE	GORY				
Landin	ng Gear			_	General	_	ı		_	7	_	7
	Bending				Bend		Grain		<u> </u>	Ovalized	<u>L</u>	Pressure/Forced
; -	Centre N	ot Conce	ntric to	o/s	BOM/Route	\vdash	Hardwa			Over/Under	 -	Temperature/Cure
1	Cracks				Broken/Damaged	-		ion Incomplete		Part Incorre	 	Weld
ļ	Crushed	Crimped			Burrs	\vdash		tions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	\vdash	Mainte			Part Moved		
	Heat Tre	at			Countersink	-	Mislabe			Positioned V		7
	····	n Strip in	Tube	_	Cut Too Short	1	Misread	d		Power Loss/	Surge	Other
	Ripples i	n Bend			Drill Holes	\vdash	Offset					
	Torque V	Vaves in I	Extrusio	n	Drawing		Out of	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish Folio

Work Orde		6007		*1060	าก7*						Page 2	
tem ID: Revision ID:	D3245-5 Door		o discondi tory (CLO 2	Accept	*N900	<u>040</u>	100)* s	etup Star	171	S1* S2*	
Start Date: Required Date: Reference:	8/28/13 8/28/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item Customer:							
Approvals:	Process Pla	an:	Date:			ate:		R	tun Sta Sto		R1* R2*	
Sequence ID/ Work Center II 120 *120*	D	Operation Description QC8- Inspect parts - second	and check	Set Up/ Run Hours 0.00 27	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
QC Quality Control		Memo		0.00 YS 12 1	<i>(</i> Q			<u></u>				
130 *130* Brake NC Brake NC		NC BRAKE Memo Deburr if no	ecessary	0.00		DAS 30 9-89		4			10/12/	[
		Form D324 Identify as I	5-5 as per Dwg D3245 D3245-5	SM								
*140 *140*		QC5- Inspect part comp	leteness to step on W/O	0.00	16			4				

Memo

Quality Control

											DQA	: Date	e: _	
NCR: Y	'es	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE		•		
											QA Closed	: Date	e:	
Work Orde	ır.					DISPOSITION				AGAINST D	EPARTMEN [®]	T/PROCESS		
Work Orde	-					Rework	7		Skid-tube	Crosstube	7	Water Jet		Engineering
Part N	lo.					Scrap	1	l .	Machining	Small Fab	Pro	od. Eng. Coor.		Quality
	•			-		Use-as-is]	Thern	noforming	Finishing	Rec/Sto	ore/Packaging		Other
NCR N	Ю.					Work Order Update			Large Fab	Composite	_	Supplier		
Root				<u> </u>	Descri	ption of work order update		Initial	Ac	tion	Sign &		T	
Cause		Date	Step	Qty		or Non-conformance		nief Eng		cription	Date	Verification		QC Inspector
Doc/Data			<u> </u>										\Box	
Equip/Tooling							1							
Operator			Į								1			
Material							1						- 1	
Setup														
Other		1												
Process														
Supplier												,		
Training														
Unapproved														
						1	AUI	LT CATE	GORY					
Landi	ng (Gear				General								
•		Bending				Bend		Grain		Γ	Ovalized			Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route	Г	Hardwa	ire	Γ	Over/Unde	er tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorr	ect		Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete	/Unclear	Part Lost/N	/lissing		Wrong Stock Pulled

Part Moved

Positioned Wrong Power Loss/Surge

Other

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Turning Sequence Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde		6007		*106	S007*						Page 3
Item ID: Revision ID: Item Name:	D3245-5			Accept	*N900040	100	*	Setup	Start Stop	*N:	S1* S2*
Start Date: Required Date: Reference:	8/28/13 8/28/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item ID: Customer:			_	S4. 4		
Approvals:	Process Pla	an:	Date:	Tooling:	Date:			Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	Date:				Stop	*N	R2*
Sequence ID/ Work Center II 150 *150* Packaging Packaging	D	Operation Description Identify as per dwg & S	tock Location:	Set Up/ Run Hours 0.00	Tool ID Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
160 *160* QC Quality Control		QC21- Final Inspection Memo	- Work Order Release	0.00			/X	m 113	13/12	113 18 ,	

		ENG.	*	•
DQA:	Date:			

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

	,								QA Closed:	Date):
Mark Orde	<u>.</u>		• •		DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Work Order Part No	414.4				Rework Scrap Use-as-is	The	Skid-tube Machining rmoforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	o				Work Order Update		Large Fab	Composite	, necyston	Supplier	
Root				Descri	ption of work order update	Initial	A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Er	ng Des	cription	Date	Verification	QC Inspector
Doc/Data											
quip/Tooling											
Operator											
Material											
Setup		1					ľ				
Other								•			
Process											
Supplier											
Training [1	
Jnapproved						<u> </u>					
					F	AULT CA	TEGORY				
Landin	g Gear			_	General	_		_	٦	_	
1	Bending				Bend	Grai	n	_	Ovalized	_	Pressure/Forced
	Centre No	ot Conce	ntric to (o/s	BOM/Route	Hard	ware	<u></u>	Over/Under	tolerance	Temperature/Cure
L	Cracks				Broken/Damaged	Inspe	ection Incomplete		Part Incorre	⊢	Weld
	Crushed/	Crimped		L	Burrs	Instr	uctions Incomplete	e/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mai	ntenance	L	Part Moved		
	Heat Trea	∍t			Countersink	Misla	abeled		Positioned \	Wrong	
	Inspectio	n Strip in	Tube		Cut Too Short	Misr	ead		Power Loss/	'Surge	Other
[Ripples in	n Bend			Drill Holes	Offse	et				<u> </u>
	Torque V	Vaves in I	Extrusio	n [Drawing	Out	of Calibration				
	Torque Waves in Extrusion Turning Sequence			Finish	Out	of Sequence		•			
	Wave/Tw	vist in Tu	be		Folio	Outs	ide Dimensions				

Page 1

Work Order ID:

106007

Parent Item:

D3245-5

Parent Item Name:

Door

Start Date: 8/28/13

Required Date: 8/28/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP A04.07.07New issueKJ/JLM
IPP Rev. b FCN 1052 07-10-31 DD verified by ILM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA 304/316 .032 Sheet		Purchased	No			100	sf	450.5000	0.07	0.2947368	A	= 13	12.14
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT020		450.5							
				11827	71	10.76							
				12086	66	54.87							
				12188	39	64.87							
				m126		320			12	6593-	\rightarrow	.30	o د

DQA: Date:

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

NCN. 16	5 / 110				WORK ONDER HORS-C			MARGE / OF E		QA Closed:	Date	e:
Work Order:	:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No)				Rework Scrap		ľ	Skid-tube Machining	Crosstube Small Fab	-1	Water Jet d. Eng. Coor.	Engineering Quality
NCR No)				Use-as-is Work Order Update] '		oforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root				Descri	ption of work order update	Init	ial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data											=	
quip/Tooling												
Operator	_									<u> </u>		
Material	_											
Setup	_											
Other	_					Ì						·
rocess												
Supplier												
Training	4											
Jnapproved			i								L	
						AULT (CAIL	GORY				
Landing					General				<u></u>	Ovalized	Г	
-	Bending			o /s	Bend BOAA/Double	\vdash	rain			Over/Under	talaranaa	Pressure/Forced Temperature/Cure
-	Centre No	ot Conce	ntric to (^{5/5} -	BOM/Route		ardwa		-	Part Incorre	F	Weld
-	Cracks	'C:		<u> </u>	Broken/Damaged	_	-	on Incomplete	Linelaar —	4		Wrong Stock Pulled
	Crushed/	Crimpea		<u> </u>	Burrs			ions Incomplete/I nance	Unclear	Part Lost/Mi Part Moved	izziug [wrong Stock Pulled
<u> </u>	Cuffs			<u> </u>	Contamination Countersink	\vdash	islabe		-	Positioned V	Mrong	
-	Heat Trea		Tubo	-	Cut Too Short		isreac		ļ	Power Loss/		Other
	Ripples in		ilube		Drill Holes	-	isreac ffset			J. Ower Loss/	Juige [Other
-	Torque V		Evtrucio	<u>,</u>	Drawing	\vdash		Calibration				
<u> </u>	Turning S			" 	Finish	\vdash		Sequence				
1	Tructum 8 3	requence	•	1	Triniari	1 10	ut OI .	cquence				

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

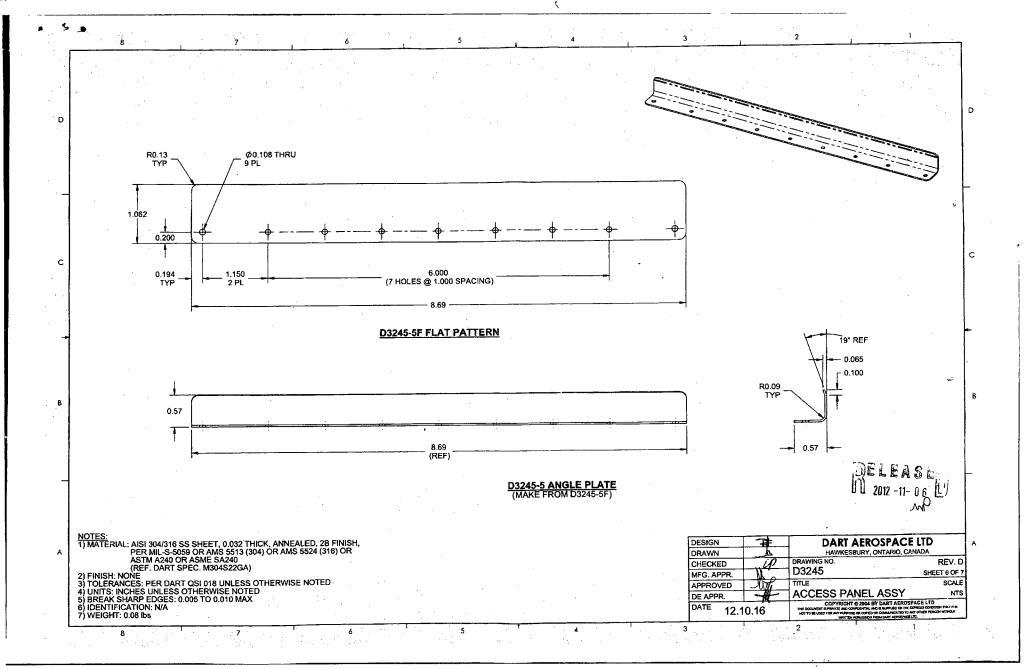
DART AEROSPACE LTD	Work Order:	106007
Description: Angle Plate	Part Number:	D3245-5
Inspection Dwg: D3245 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

		AKTIOEE III		- -		1
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.200	+/-0.010	,200	(V	JKm-05
0.194	+/-0.010	,194	1		V	
1.062	+/-0.010	1.062	-			
1.150	+/-0.005	1.150	1		V	
1.000	+/-0.010	1.000	-		V	
6.000	+/-0.010	6,000	(7	JKM-06
8.69	+/-0.030	8.69			T	
Ø0.108	+0.005/-0.001	.112				
	Ave. Market and the second and the s					
	·		DAS-	<u></u>		

Measured by: be	Audited by:	27	Preliminary Approval:	
Date: 13.12.14	Date:	10 13 00 11	Date:	

Rev	Date	Change	Revised	by	Approved
A	08.09.04	New Issue	KJ/DD		
В		Dimensions updated per Dwg Rev C	KJ 15		-11
C.	13.06.17	Dwg Rev updated	KJ of	1	/\$ {\



106007 MLJ 13-08-29